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ABSTRACT OF THE DISCLOSURE

Sub 21 } ~~A suction control unit in a plate suction and lifting device that can suck~~  
and lift even the plate with process holes or the corrugated plate by finding  
the suckable flat part of the plate. A suction control unit 1 controls a plate  
suction and lifting device 2 for lifting a plate W by sucking the flat part of  
the plate W by a suction pad 4. The suction control unit 1 is equipped with a  
suction pressure detecting means 19 and a retry control unit 29. The retry  
control unit 29 detects the suction pressure of the suction pad 4. The retry  
control unit 29 sucks the plate again if the suction pressure of the suction  
pressure detecting means 19 does not reach the set pressure when the suction pad  
4 sucks the plate W. This suction is implemented again by changing the flat  
~~part of the plate W sucked by the suction pad 4.~~